

Date: Friday, 01/08/2008 2:33:39 PM
User: Julie Lecocq

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: BACK LEG ASSEMBLY
Job Number	: 40873 -2	Part Number	: D3782045
Estimate Number	: 13323	Drawing Number	: D3782 REVA
P.O. Number	:	Project Number	: N/A
This Issue	: 01/08/2008 S.O. No. :	Drawing Revision	: A
Prsht Rev.	: NC	Material	:
First Issue	: 31/07/2008 Type : SMALL /MED FAB	Due Date	: 08/08/2008
Previous Run	: 40306	Qty:	24 Um: Each
Written By	:		
Checked & Approved By	: <u>JUL 08 8 01</u>		
Comment	: Est Rev:A 08-05-19 new issue DD verified by:ec Est Rev:B 08-06-17 rev.A as per dwg DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
Pick Packing Kit

2.0	D37721	Back Leg
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Machinist



Comment: Qty.: 1.0000 Each(s)/Unit Total : 24.0000 Each(s)

Back Leg

batch: 40989

FF 08/09/16

3.0	D37871	Foot
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 24.0000 Each(s)

Foot

batch: m 40982

FF 08/09/16

4.0	D37641	Back Leg Fitting
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 24.0000 Each(s)

Back Leg Fitting

batch: m 40970

FF 08/09/16

5.0	D3773041	Headrest Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 24.0000 Each(s)

Headrest Assembly

batch: B40980

FF 08/09/16

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 01/08/2008 2:33:39 PM
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Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: BACK LEG ASSEMBLY

Job Number: 40873

Part Number: D3782045

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	D37861	Sleeve
-----	--------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 24.0000 Each(s)

Sleeve

batch: 7 40981

FF 08/09/16 (10)

7.0	AN515A	Bolt
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 24.0000 Each(s)

Bolt

batch: m 108880

FF 08/09/16 (10)

8.0	AN517A	Bolt
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 24.0000 Each(s)

Bolt

batch: m 108558

FF 08/09/16 (10)

9.0	AN45 15A	EYE BOLT
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 24.0000 Each(s)

EYE BOLT

batch: m 109012

FF 08/09/16 (10)

10.0	AN415A	Bolt
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 48.0000 Each(s)

Bolt

batch: M 108077

FF 08/09/16 (10)

11.0	AN960JD516	Washer
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Comment: Qty.: 5.0000 Each(s)/Unit Total : 120.0000 Each(s)

Washer

batch: 17108672

or (NAS1149D0568J)batch: _____

FF 08/09/16 (10)

12.0	AN960JD416	Washer
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 96.0000 Each(s)

Washer

batch: m 108161

or (NAS1149D0463J)batch: _____

FF 08/09/16 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 01/08/2008 2:33:39 PM
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Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: BACK LEG ASSEMBLY

Job Number: 40873

Part Number: D3782045

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

MS21042L4

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 48.0000 Each(s)

Nut

batch: M107499

FF 08/09/16 (10)

14.0

MS21042L5

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total: 72.0000 Each(s)

Nut

batch: M108161

FF 08/09/16 (10)

15.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-assemble as per dwg D3782

FF 08/09/16 (10)

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/09/16 (10)

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

(2 FRANS)
ST 250 08/09/17 (8)

18.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/18

Job Completion



MF 08-09-16

MF 08-09-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-043)
1	D3768-3	FRONT OUTBOARD LEG, LH	1
2	D3787-1	FOOT	1
3	D3762-041	FRONT LEG FITTING ASSY	1
4	AN45-13A	EYE BOLT	2
5	MS21042L5	NUT	2
6	NAS1149D0568J	WASHER (AN960JD516)	2

D3782-043 FRONT OUTBOARD LEG ASSY, LH

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.42 lbs

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	<i>[Signature]</i>	DRAWING NO. D3782	REV. A
MFG. APPR.	<i>[Signature]</i>	SHEET 2 OF 4	
APPROVED	<i>[Signature]</i>	TITLE LEG ASSEMBLY	SCALE NTS
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DATE	08.06.04		

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06-16-10

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WORK ORDER
NO. *40873*

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-044)
1	D3768-4	FRONT OUTBOARD LEG, RH	1
2	D3787-1	FOOT	1
3	D3762-041	FRONT LEG FITTING ASSY	1
4	AN45-13A	EYE BOLT	2
5	MS21042L5	NUT	2
6	NAS1149D0568J	WASHER (AN960JD516)	2

D3782-044 FRONT OUTBOARD LEG ASSY, RH

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.42 lbs

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3782	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LEG ASSEMBLY	NTS
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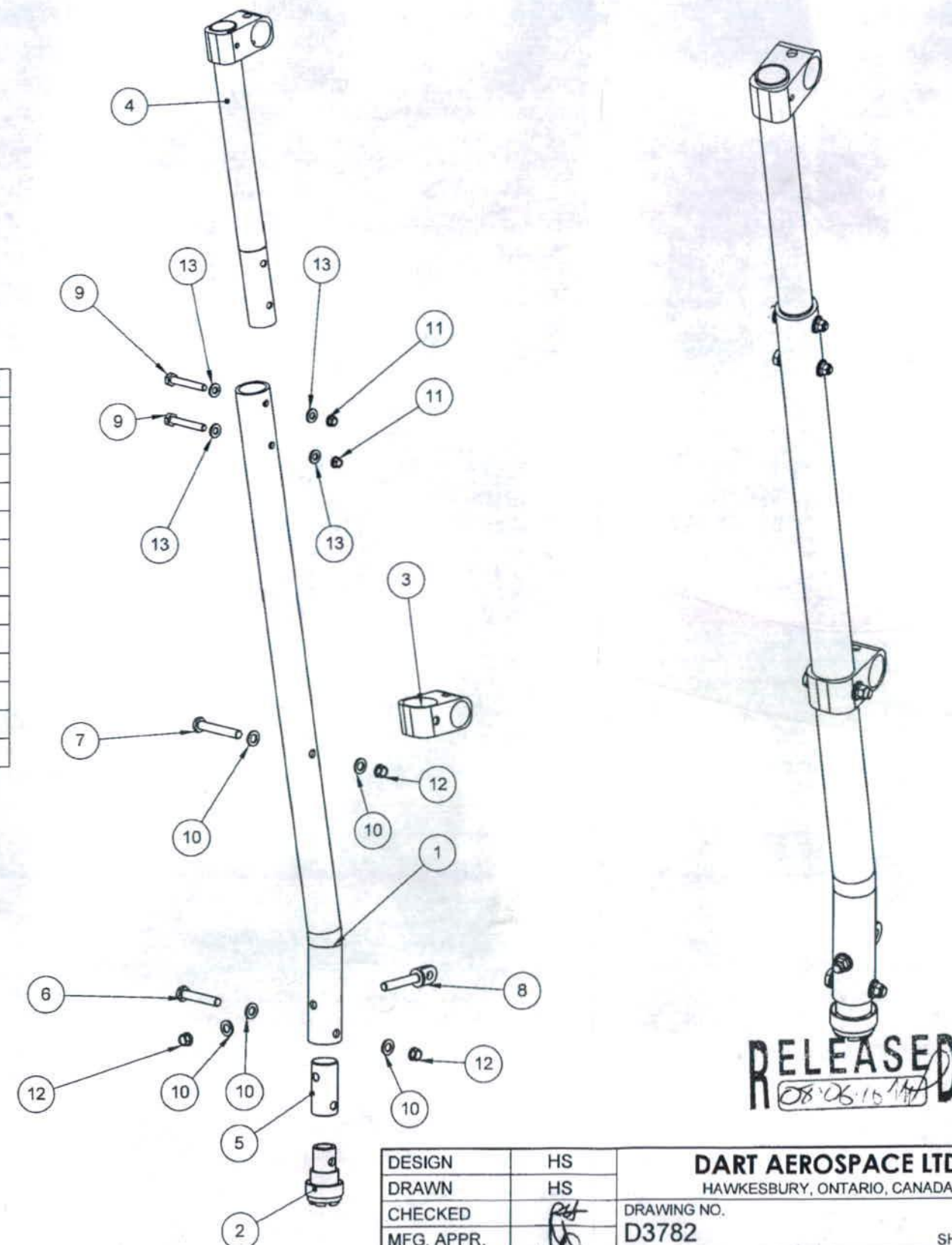
RELEASED
08.06.16/14

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-045)
1	D3772-1	BACK LEG	1
2	D3787-1	FOOT	1
3	D3764-1	BACK LEG FITTING	1
4	D3773-041	HEAD REST ADAPTER ASSY	1
5	D3786-1	SLEEVE	1
6	AN5-15A	BOLT	1
7	AN5-17A	BOLT	1
8	AN45-15A	EYE BOLT	1
9	AN4-15A	BOLT	2
10	NAS1149D0568J	WASHER (AN960JD516)	5
11	MS21042L4	NUT	2
12	MS21042L5	NUT	3
13	NAS1149D0463J	WASHER (AN960JD416)	4

D3782-045 BACK LEG ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 4.71 lbs



DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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CHECKED		DRAWING NO.	REV. A
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APPROVED		TITLE	SCALE
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